

Work Order ID 81800

81800

Page 1

March-19-12 1:33:37 PM

Item ID: D3414-041 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Lug Assembly
 Start Date: 19/03/2012 Start Qty: 8.00 *8* Cust Item ID:
 Required Date: 18/05/2012 Req'd Qty: 8.00 *8* Customer:

Reference:

Approvals: Process Plan: MLJ Date: 12/03/19 Tooling: Date: Run Start *NR1*
 QC: Date: SPC (Y/N): Date: Stop *NR2*

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|

| Draw Nbr | Revision Nbr |
|----------|--------------|
| D3414 | Rev C |

| | | | | | | | | | |
|-----|--|------|--|--|--|---|---|--|----|
| 100 | | 0.00 | | | | 8 | 0 | | Jm |
|-----|--|------|--|--|--|---|---|--|----|

100
 Waterjet
 FLOW CNC Waterjet
 304, 100
 Memo
 1-Cut as per Dwg D3414-1
 Dwg Rev: C
 Prog Rev: C
 2-Deburr if necessary

| | | | | | | | | | |
|-----|---|------|--|--|--|---|---|--|----|
| 110 | QC2- Inspect parts off machine FAI/FAIB | 0.00 | | | | 8 | 0 | | Jm |
|-----|---|------|--|--|--|---|---|--|----|

110
 QC
 Quality Control
 Memo

12-5-17

12-5-17

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
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| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

Work Order ID 81800

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Item ID: D3414-041

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Lug Assembly

Start Date: 19/03/2012 Start Qty: 8.00

8

Cust Item ID:

Required Date: 18/05/2012 Req'd Qty: 8.00

8

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|---|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
| 120 | QC8- Inspect parts - second check | 0.00 | | | | | | | |
| *120* | | | | | | | | | |
| QC | Memo | 0.00 | | | | | | | |
| Quality Control | | | | | | | | | |
| 130 | | 0.00 | | | | | | | |
| *130* | | | | | | | | | |
| Brake NC | Memo | 0.00 | | | | | | | |
| Brake NC | 1-Deburr 2-Form using DT8254 as per Dwg D3414 | | | | | | | | |
| 140 | | 0.00 | | | | | | | |
| *140* | | | | | | | | | |
| Large Fab | Memo | 0.00 | | | | | | | |
| Large Fab | 1- Weld using location Jig DT9625 as per Dwg D3414 A/R S.S. welding rod Batch: <u>17120013</u> | | | | | | | | |

(18)

(2)

(8)

SB
12/05/12

EL 12-5-31

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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 QC: Date: SPC (Y/N): Date: Stop ***NR2***

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
| 150 | QC9- Inspect visual per QSI004- Fusion Welds | 0.00 | | | | | | | |
| *150* | | | | | | | | | |
| QC | Memo | 0.00 | | | | | | | |
| Quality Control | | | | | | | | | |
| 160 | QC5- Inspect part completeness to step on W/O | 0.00 | | | | | | | |
| *160* | | | | | | | | | |
| QC | Memo | 0.00 | | | | | | | |
| Quality Control | | | | | | | | | |
| 175 | Spray Painting per QSI005 4.2 | 0.00 | | | | | | | |
| *175* | | | | | | | | | |
| SprayPaint | Memo | 0.00 | | | | | | | |
| Spray Painting | PRIME B <u>117319</u> DELFLEET BLUE B <u>121149</u> CLEAR DELFLEET B <u>121703</u> | | | | | | | | |

CP 12.05.31 8x

8.7.10.31

(75)

AB 12-7-15 (8)

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
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NOTE: Date & initial all entries

Work Order ID 81800




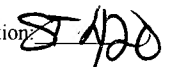


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81800

Page 4

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 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|---|---|--|---------|----------|--------------|---|---------------|------------------|--|
| 185 *185* QC Quality Control | QC14- Inspect Spray Paint Memo | 0.00  0.00 | | 12/09/16 | |  | | |  12-7-16 |
| 190 *190* Packaging Packaging | Identify as per dwg & Stock Location Memo | 0.00  0.00 | | | | 8x | | |  12-7-16 |
| 200 *200* QC Quality Control | QC21- Final Inspection - Work Order Release Memo | 0.00 0.00 | | | | | | | 12/7/17  12-07-16 |

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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NOTE: Date & initial all entries

Picklist Print

March-19-12 1:33:41 PM

Page 1

Work Order ID: 81800

81800

Parent Item: D3414-041

D3414-041

Parent Item Name: Lug Assembly

Start Date: 19/03/2012

Required Date: 18/05/2012

Start Qty: 8.00

Required Qty: 8.00

Comments: IPP A05.09.13New issueKJ/JLM

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Qty per Kit | Total Qty | Qty Issued | Date Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|
| M304S12GA | | Purchased | No | | | 100 | sf | 119.3300 | 0.155 | 1.24 | | | |

M304S12GA

304/316 0.100" Sheet

**

| Location | Loc Qty | Loc Code |
|----------|---------|----------|
| MAT019 | 119.33 | |
| 113062 | 105.1 | |
| 113077 | 14.23 | |

D3414-3

Manufactured No

140

Each

0.0000

1

8

D3414-3

Lug

**

B83320. x8

113062

Jm
12-5-17

EL 12-5-30

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

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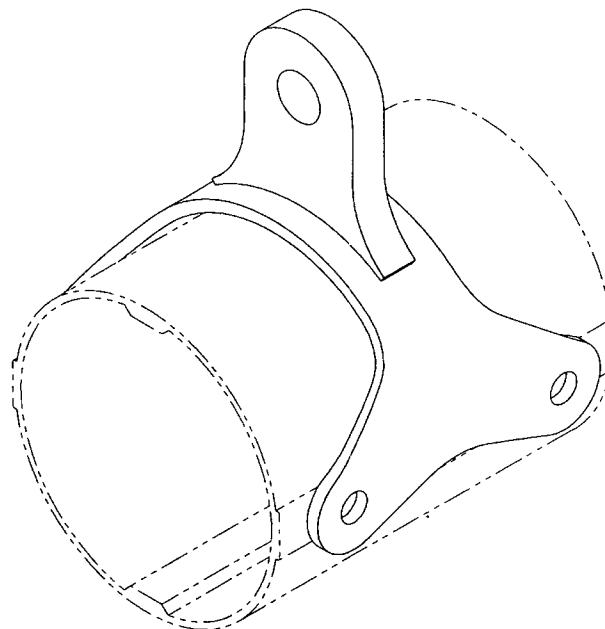
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NOTE: Date & initial all entries

| ITEM No. | QTY. -041 | PART NUMBER | DESCRIPTION |
|----------|-----------|-------------|--------------|
| 1 | X | D3414-041 | LUG ASSEMBLY |
| 2 | 1 | D3414-1 | LUG BRACKET |
| 3 | 1 | D3414-3 | LUG |



D3414-041 LUG ASSEMBLY

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 81800 MLJ
12/03/19

RELEASED
01/06/16 MP

| | | | |
|------------|--|--|--------------|
| C | BREAK SHARP EDGES FOR -3 NOW 0.030-0.060 WAS 0.010-0.030 (ZN A7-3) | CP | 09.06.17 |
| B | DRAWING REDRAWN IN SOLIDWORKS WITH CURRENT STANDARDS AND TRANSFERRED TO "B" SIZE BORDER. FLAT PATTERN FOR -1 INCREASED IN LENGTH TO PREVENT FOULING AT INSTL (SEE PAR 198). FLAT SPOTS REMOVED FROM -1 (PART NOW "U" SHAPED) FOR EASE OF MANUFACTURE. B7-3 ADDED TOLERANCE TO 3.230 DIM. C2-3 1.12 DIM WAS 1.20. | AJS | 08.09.23 |
| A | NEW ISSUE | CP | 05.03.16 |
| REV | DESCRIPTION | BY | DATE |
| DESIGN | CP | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| DRAWN | CP | | |
| CHECKED | CP | DRAWING NO. | REV. C |
| MFG. APPR. | CP | D3414 | SHEET 1 OF 3 |
| APPROVED | CP | TITLE | SCALE |
| DE APPR. | CP | LUG ASSEMBLY | NTS |
| DATE | 09.06.17 | COPYRIGHT © 2015 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSES OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD | |

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3414-041" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.52 lbs

| W/O: | | WORK ORDER CHANGES | | | | | |
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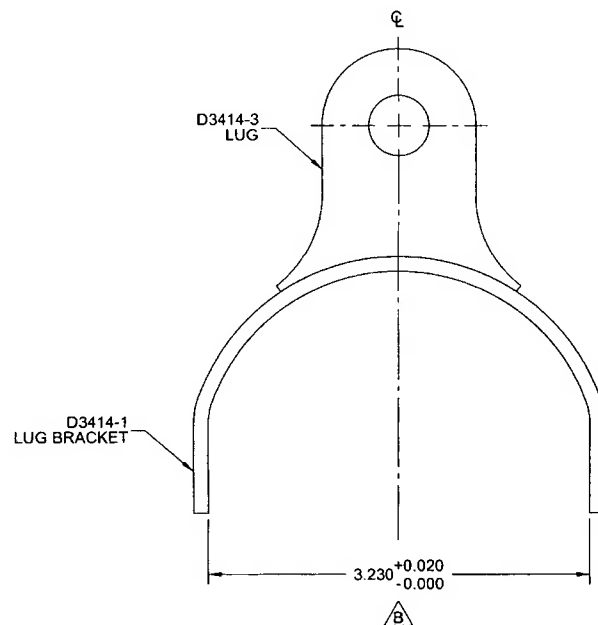
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

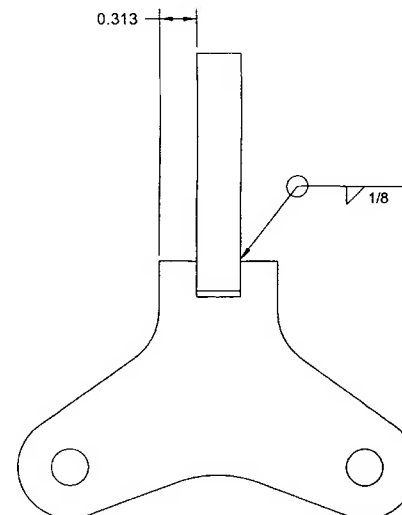
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NOTE: Date & initial all entries

81800



D3414-041 LUG ASSEMBLY



RELEASED
04/10/16 NW

| | | | |
|------------|----------|--|--------------|
| DESIGN | CP | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| DRAWN | CP | | |
| CHECKED | CP | DRAWING NO. | REV. C |
| MFG. APPR. | CP | D3414 | SHEET 2 OF 3 |
| APPROVED | CP | TITLE | SCALE |
| DE APPR. | CP | LUG ASSEMBLY | NTS |
| DATE | 09.06.17 | <small>COPYRIGHT © 2005 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small> | |

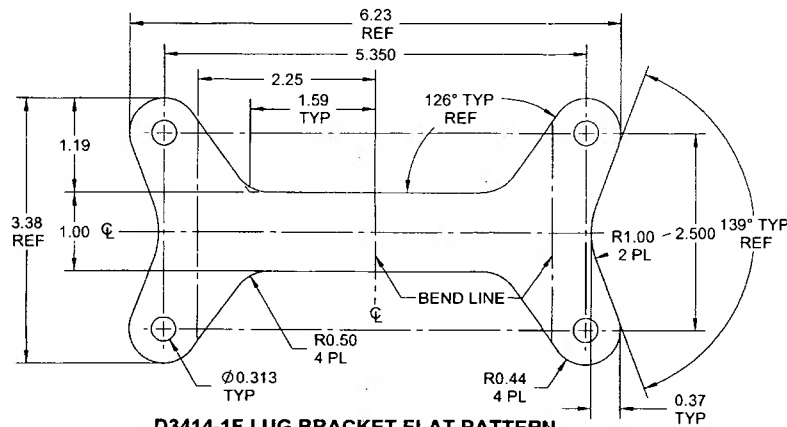
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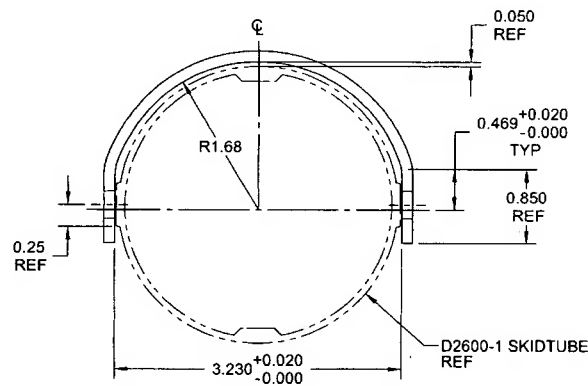
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| | | | | | | | | |

NOTE: Date & initial all entries



D3414-1F LUG BRACKET FLAT PATTERN



D3414-1 LUG BRACKET

NOTES:

1) MATERIAL: -1: AISI 304/316 STAINLESS STEEL SHEET, 12 GAUGE (0.100 THICK)
PER MIL-S-5059 (ANNEALED) 2B FINISH OR AMS 5513/5524
REF. DART SPEC. M304S12GA

-3: AISI 304/316 STAINLESS STEEL PLATE
PER MIL-S-5059 (ANNEALED) 2B FINISH OR AMS 5513/5524
REF. DART SPEC. M304S

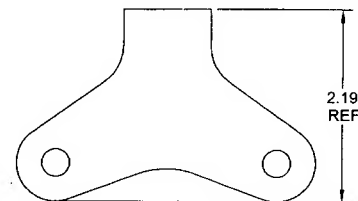
2) FINISH: N/A
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

4) UNITS: INCHES UNLESS OTHERWISE NOTED

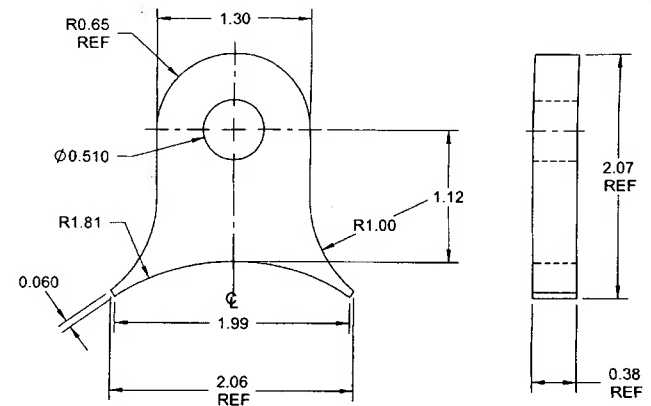
5) BREAK SHARP EDGES: -1: 0.010 TO 0.020 MAX
-3: 0.030 TO 0.060 MAX

6) IDENTIFICATION: N/A

7) WEIGHT: N/A



SIDE VIEW FOR REF ONLY



D3414-3 LUG

RELEASED

| | | | |
|------------|----------|---|--------------|
| DESIGN | OP | DART AEROSPACE LTD | |
| DRAWN | OP | HAWKESBURY, ONTARIO, CANADA | |
| CHECKED | | DRAWING NO. | REV. C |
| MFG. APPR. | | D3414 | SHEET 3 OF 3 |
| APPROVED | | TITLE | SCALE |
| DE APPR. | | LUG ASSEMBLY | NTS |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DGA _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed _____ Date: _____

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| | 1 | | | | | | | |
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